

Work Order ID 63562

Thursday, November 04, 2010 1:09:46 PM



Page 1

Item ID: D2150

Accept



Setup Start



Revision ID:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2150	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2150

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

10-11-02

12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-11-02

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/17

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Start Date: 11/4/2010 Start Qty: 12.00

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Customer:




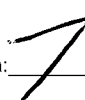
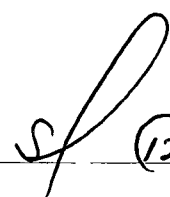


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		2)  10/11/30		12	0		
170  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00				10/11/30		(12)	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				CL 10/12/01			CL 10/11/30

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Picklist Print

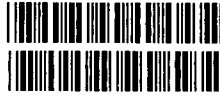
Thursday, November 04, 2010 1:09:51 PM

Page 1

Work Order ID: 63562

Parent Item: D2150

Parent Item Name: Packer Doubler, Hinge




Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP ☐C☐00.11.27☐Re-format (mpp 2101)☐EC☐
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	280.8400	0.025	0.315789			
													
2024-T3 .040 sheet													



1810-11-22

Location

Loc Qty

Loc Code

MAT

71.6

114415

71.6

114415

(12)

MAT22

209.24

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

97.4

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	43562
Description: Packer		Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	.743	X		V 1802	
2.050	+/-0.010	2.050	X		V	
0.231	+/-0.010	.231	X		V	
1.217	+/-0.010	1.218	X		V	
1.559	+/-0.010	1.566	X		V	
2.300	+/-0.010	2.303	X		V	
1.560	+/-0.010	1.560	X		V	
0.250	+/-0.010	.250	X		V	
1.328	+/-0.010	1.330	X		V	
0.342	+/-0.010	.347	X		V	
Ø0.098	+0.005/-0.000	.098	X		V	
Ø0.171	+0.005/-0.000	.171	X		V	
0.040	+/-0.010	.042	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-11-20	Date: 10/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	

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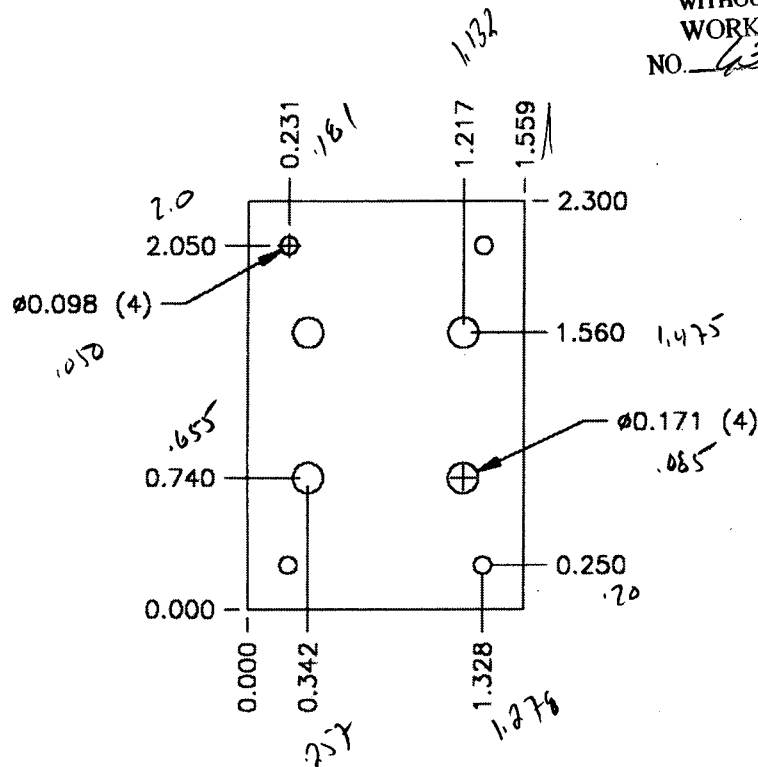
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2150	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:05:01	PACKER	1:1	

RELEASED
96/06/13 BWS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43542



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
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